












Date: Friday, 23/05/2008 2:18:05 PM  
User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CLEVIS
Job Number	: 39462	Part Number	: D34533
Estimate Number	: 10578	Drawing Number	: D3453 REV A
P.O. Number	:	Project Number	: N/A
This Issue	: 23/05/2008 S.O. No. :	Drawing Revision	: A
Prsht Rev.	: NC	Material	:
First Issue	: / / Type : MACHINED PARTS	Due Date	: 15/06/2008
Previous Run	: 39462	Qty:	10 Um: Each
Written By	:		
Checked & Approved By	: <u>J.L. 08.5.23</u>		
Comment	: A 05.09.27 New issue EC		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M304R1250	Inventory	
			
Comment: Qty.: 0.2452 f(s)/Unit Total : 1.4712 f(s) Material: AISI 304 SS Round Bar Ø1.250 (M304R1.250) Batch: <u>M105072</u> <u>mmf 08/05/25</u>			
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
			
Comment: HARDINGE CNC LATHE SMALL 1-Turn as per Folio FA578 Rev: <u>AA</u> & Dwg D3453 Rev: <u>A</u> 2- Deburr as per dwg D3453 <u>mmf 08/05/25</u>			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>mmf 08/05/25</u>			
4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
			
Comment: HAAS CNC VERTICAL MACHINING #1 1-Mill as per Folio FA578 Rev: <u>AA</u> & Dwg D3453 Rev: <u>A</u> 2- Deburr as per dwg 3453 <u>J.L. 08/07/14</u>			
5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>J.L. 08/07/14</u>			

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3453-3 PAR #: N/A Fault Category: Prod / Machine <sup>PAB</sup> NCR: (Yes) No DQA: IS Date: 08/07/09  
D3463-041/010 QA: N/C Closed: RD Date: 08/07/10

NCR: <u>39462</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/07/09	H	1 part scrapped 6" slitting saw pushed part in collet causing dimensions to be off by 0.30 R.L. Saw was Dull.		Scrap and Destroy no replace Qty (X)	J.L. 08/07/09	S 08/07/09		S 08/07/09
08/07/08	# 4/0	one part was turned too short on lathe. was not noticed until it was <sup>machined</sup> <del>more</del> on mill. R.C. end of a BAR		Scrap and Destroy no replace Qty (X)	J.L. 08/07/08	C 08/07/08		S 08/07/08

NOTE: Date & initial all entries

Date: Friday, 23/05/2008 2:18:05 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLEVIS

Job Number: 39462

Part Number: D34533

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

1- Drill as per dwg D3453

2-Deburr as per dwg D3453

10 08/07/17 (8)

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

24 08/07/18

8.0

QC8

SECOND CHECK



Comment: SECOND CHECK

24 08/02/18

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 95

567/18

(8x)

54

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/21/18

Job Completion



u 08/07/21

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

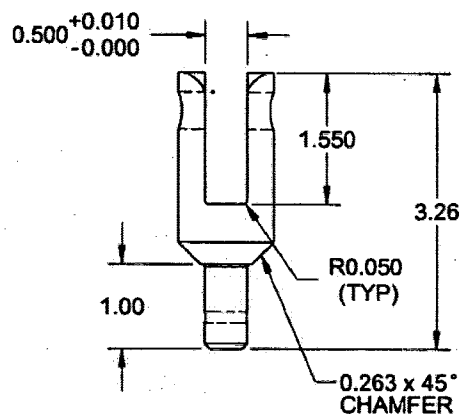
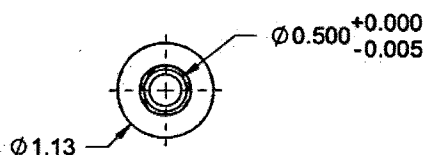
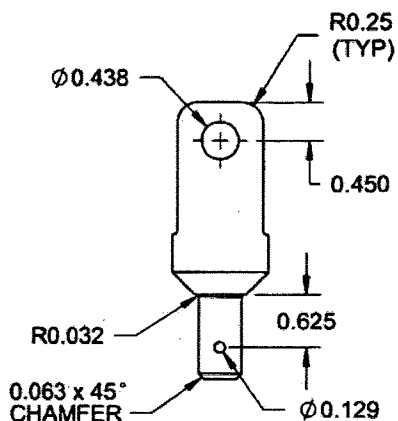
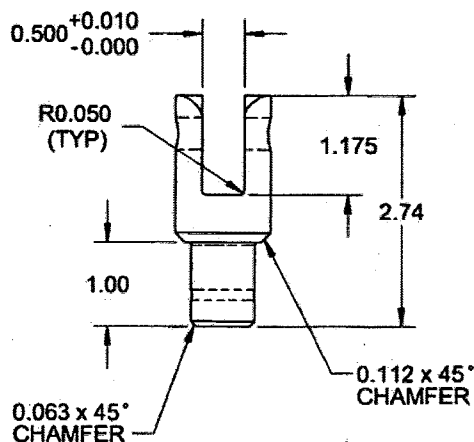
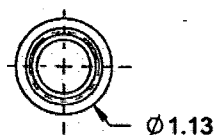
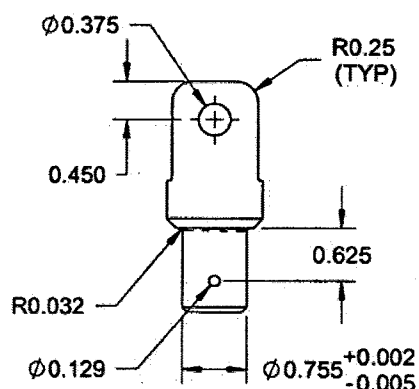
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**DART**

DESIGN RF	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3453</b>	REV. A SHEET 1 OF 2
DATE <b>05.09.02</b>	TITLE <b>CLEVIS</b>		SCALE 12
A	05.09.02	NEW ISSUE	

**D3453-1 CLEVIS****RELEASED**05.12.09 *[Signature]***D3453-3 CLEVIS****NOTES:**

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *39462*

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

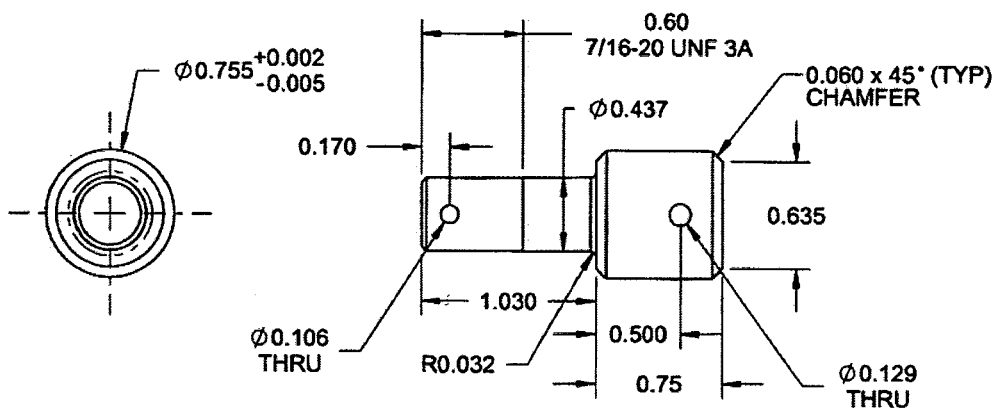
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

**DART**

DESIGN RF	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. <b>D3453</b>	REV. A SHEET 2 OF 2
DATE <b>05.09.02</b>		TITLE <b>CLEVIS</b>	SCALE 1:1

**RELEASED**

05.12.09 [Signature]

**D3453-5 PLUG****NOTES:**

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC. M304R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 39462

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.